Work Order ID 50986

C

Page 1

July 28, 2009 1:55:53 PM

Required Date: 8/05/09

Item ID:

D2232-3

Basket Hinge

Accept

Setup Start

Stop



Revision ID: Item Name:

Start Date:

7/30/09

Start Qty: 6.00 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

	-	
Α	pprovals:	

Process Plan:

Tooling:

Date:

Start



QC:

Date:

Date: _____

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

Operation Description Set Up/ **Run Hours** Draw Number

Plan Draw Rev. Code Accept Qty

Reject **Qty**

Run

Reject Insp. Number Stamp

Draw Nbr

Revision Nbr

D2232

Rev C

100

FLOW WATER JET

Memo

0.00

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2232 | Dwg Rev: C | DProg Rev: C | Deburr if necessary

110

Waterjet

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

Quality Control

120

QC8- Inspect parts - second check

Memo

=> Soulutor

QC

Memo

Quality Control

Dart Aero	space	Ltd
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W/O:			W	ORK ORDER CHANG	ES							
DATE	STEP	PRO	OCEDURE CHA	ANGE	By	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
									:	·		
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Y	es N	o DQ /	A :	_ Date: _			
	R	esolution:	Disposition	on:	_ QA: N/0	Clos	sed:		Date:			
NCR:		\	WORK ORD	DER NON-CONFORMA	ANCE (N	CR)						
DATE	STEP	Description of NC		Corrective Action Secti			Verific	ation	Approval	Approval		
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	SI	gn & ate	Section C		Section C		Chief Eng	QC Inspector
								. 11.		i P		
										-		

Page 2

July 28, 2009 1:55:53 PM Item ID:

D2232-3

Revision ID: C

Basket Hinge Item Name:

Start Date: Required Date: 8/05/09

7/30/09

Start Qty: 6.00

Reg'd Qty: 6.00



Accept

Cust Item ID:

Customer:

Setup Start

Stop



Reference:

Approvals:

Process Plan: QC: ____

Date:

Tooling: Date:

SPC (Y/N):

Date:

Date:

Start Run

Reject

Qty

Stop



Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo Debur

Set Up/ **Run Hours** Draw Number

Draw Rev.

Plan Code

Accept Qty

Reject

Insp. Number Stamp

0.00

140

Packaging

Packaging

Identify as per dwg & Stock Location:_

Basket cell

Memo

0.00

0.00

QC21- Final Inspection - Work Order Release

0.00

150

Quality Control

Memo

0.00

Dart Aerospace Ltd

W/O:	•		W	ORK ORDER CHANGI	ES ·				•
DATE STEP F			ROCEDURE CHANGE			Da	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cat	tegory:	NCR: Ye	s No	DQA:	Date: _	
	R	esolution:	Dispositi	on:	QA: N/C	Closed	d:	Date: _	
NCR:		V	VORK ORI	DER NON-CONFORMA	NCE (N	CR)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	Sig	n &	/erification Section C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Da	te			
		:							

Picklist Print

July 28, 2009 1:55:53 PM

Work Order ID: 50986

Parent Item:

D2232-3RevC

Parent Item Name:

Basket Hinge

Comments:



Start Date: 7/30/09

Required Date: 8/05/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Purchased

Bin Primary Location Item

Last Location

Route Seq ID

Unit of Measure

Qty on Hand

Remaining Qty **Qty To Pick** Issued

Date Issued

Status

M304S11GA

No

100

sf

105.7716 0.4383

17

304/316 0.125 Sheet

Warehouse

Loc Oty

Loc Code

Location

Main Warehouse

MAT

105.7716032

111018

105.771603

111018 IB 9-7-29



Dart	Aero	space	Ltd
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W/O:			W	ORK ORDER CHANGE	S				· *
DATE	STEP	PRO	CEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A :	Date: _	
	R	esolution:	Dispositi	on:	QA: N/C C	osed:		Date: _	
NCR:			WORK ORI	DER NON-CONFORMA	NCE (NCF	₹)			
DATE	STEP	Description of NC	Initial	Corrective Action Section			cation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng		Sign & Section C	Chief Eng	QC Inspector	
		_							
								:	

DART AEROSPACE LTD	Work Order:	50986
Description: Basket Hinge	Part Number:	D2232-3
Inspection Dwg: D2232 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X First Article Prototype								
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
0.500	+/-0.010	. 500	*						
0.750	+/-0.010	1750	*						
2.500	+/-0.010	102.6	x						
1.000	+/-0.010	1.00	4						
0.750	+/-0.010	. ,750	x						
2.250	+/-0.010	9.352	کھ						
0.500	+/-0.010	Sol	A						
Ø0.257	+0.006/-0.001	-369	×						
	7.								

			\sim		
Measured by:	B	Audited by:	2,	Prototype Approval:	N/A
Date:	9-7-29	Date:	09/423	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.11.08	New Issue	KJ/JLM A	E

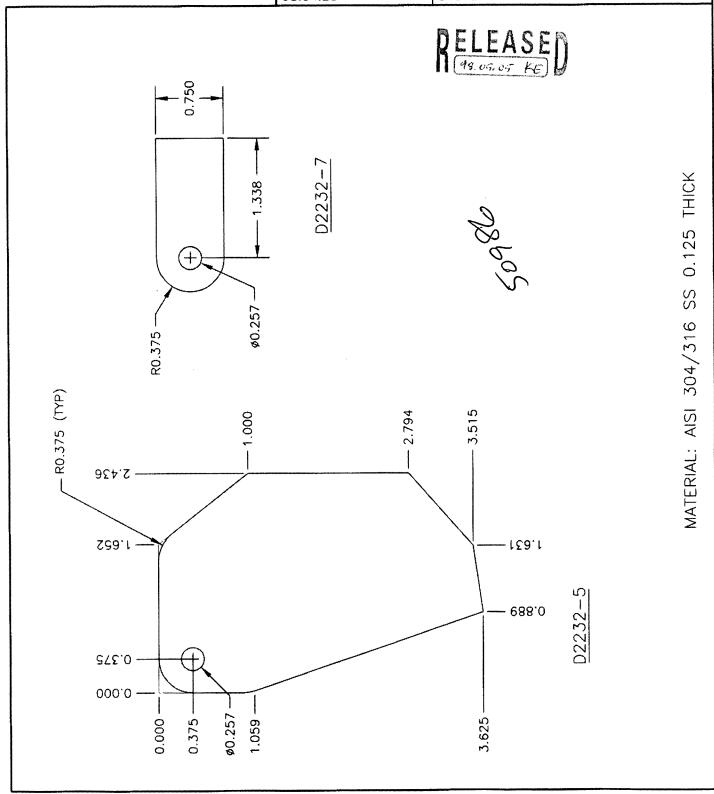
Dart Aerospace Ltd	1
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W/O:			WO	RK ORDER CHANGES	5				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							3	• .	
								3	
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	Date:	
Resolution:		esolution:	Disposition: QA			:: N/C Closed: Date:			
NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCF	R)			
DATE	STEP	Section A	Initial	Corrective Action Section Action Description	Sign 8	Verific Secti	cation	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date	ate		- Children	QO IIISPECIOI
				•					





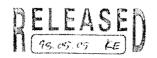
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DATE	''')	TITLE	SCALE
98.04.28		BASKET HINGE	1:1





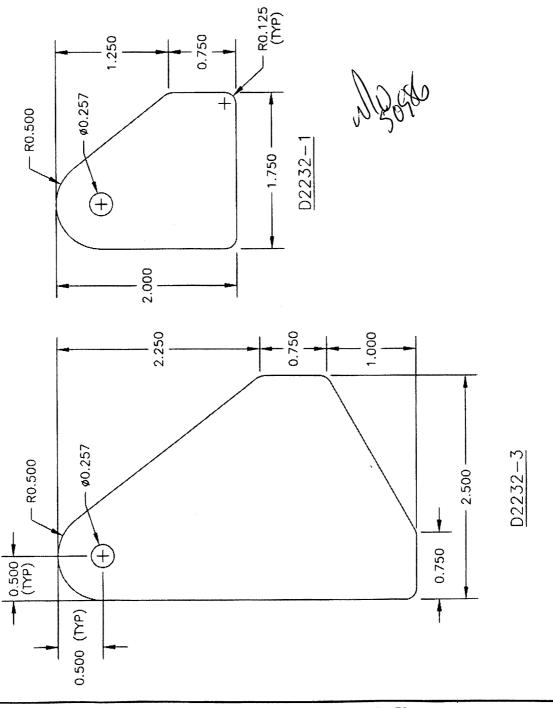


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DATE	· · · · · · · · · · · · · · · · · · ·		TITLE	SCALE		
98.0	4.28		BASKET HINGE	1:1		
 Α		94.05.12	NEW ISSUE			
			T			



98.04.28		BASKET HINGE	1:1	
Α	94.05.12	NEW ISSUE		
В	96.01.02	ADDED -5 AND -7		
С	98.04.28	0.125 THICK WAS 0.063		

MATERIAL: AISI 304/316 SS 0.125 THICK



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